Work Order ID 66148

Monday, February 07, 2011 11:11:03 AM

Item ID: D3564-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Wearshoe

Start Date: 2/8/2011 **Start Qty:** 16.00 **Cust Item ID:**

Required Date: 2/22/2011 **Req'd Qty:** 16.00 **Customer:**

Reference:

Approvals: **Process Plan:** VMF **Date:** 11-02-07 **Tooling:** ______ **Date:** ______ **Run Start** **Stop**

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3564	Rev D

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Accept Qty	Reject Qty	Reject Number
100 Waterjet FLOW CNC Waterjet 304 .063	FLOW WATER JET **Memo** 1-Cut as per Dwg D3564 ☐Dwg Rev: D ☐Prog Rev: D ☐2-Deburr if necessary	0.00 0.00	[initials] 11-2-8		
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	HB 11-2-8		
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	[initials] 11	02	08 (17)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66148

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Start Date: 2/8/2011 **Start Qty:** 16.00 **Cust Item ID:**

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Run **Start** **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE	0.00				17			
	Memo Deburr if necessary□Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155□Form Joggle as per Dwg D3564 on brake using Jig DT8157 SD 11/02/09	0.00							
140 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				M	11	02	08 (17)
	Memo Ensure joggle as per dwg D3429	0.00							
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				17.	BR	11-2-11.	
	M 11/3/08 **Memo** START TIME: 3:45 □OVEN TEMPERATURE: 300□FINISH TIME: 4:15	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 66148

Monday, February 07, 2011 11:11:03 AM

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Revision ID:

Item Name: Wearshoe

Start Date: 2/8/2011 **Start Qty:** 16.00

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Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				17	∅	[initials]	11/02/15
170 Packaging Packaging	Identify as per dwg & Stock Location: FP-19 **Memo**	0.00 0.00				17		[initials]	11-02-15.
180 QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00				[initials]		11/02/15	

[initials] 11-02-15

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, February 07, 2011 11:11:00 AM

Work Order ID: 66148

Parent Item: D3564-5

Parent Item Name: Wearshoe

Start Date: 2/8/2011 **Required Date:** 2/22/2011

Start Qty: 16.00 **Required Qty:** 16.00

Comments:

IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	222.2800	1.5	25.26316 IBil-2-8			

Location	Loc Qty	Loc Code
MAT	222.28	
111323	0	
116623	222.28	

116623

(17)

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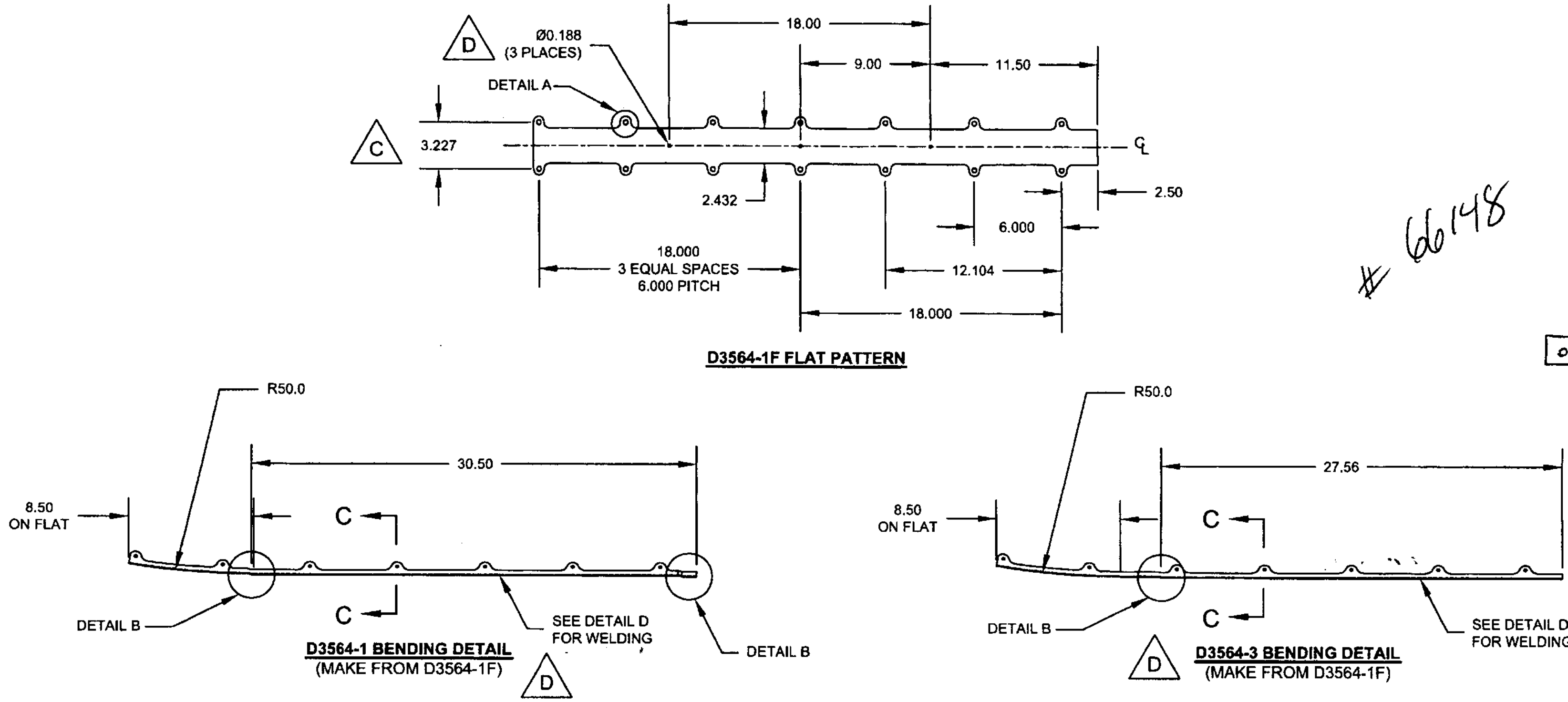
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes No **DQA:** ______ **Date:** ________

Resolution: ________ **Disposition:** ________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries



66148

RELEASED
07.09.04

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
   (REF DART MATERIAL SPEC M304S16GA)
2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: SEE TABLE IN ZONE A3
8) WELD PER DART QSI 004
9) SEE PG 3 FOR SECTIONS AND DETAILS
10) PARTS ARE SYMMETRIC ABOUT ℄

WEIGHTS:

Part	Weight
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

REV.	DESCRIPTION	BY	DATE
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	CB	
CHECKED	PH	DRAWING NO. D3564 — REV. D — SHEET 1 OF 3
MFG. APPR.	[illegible]	
APPROVED	[illegible]	TITLE: WEARSHOE — SCALE 1:8
DE APPR.	[illegible]	
DATE	07.08.21	

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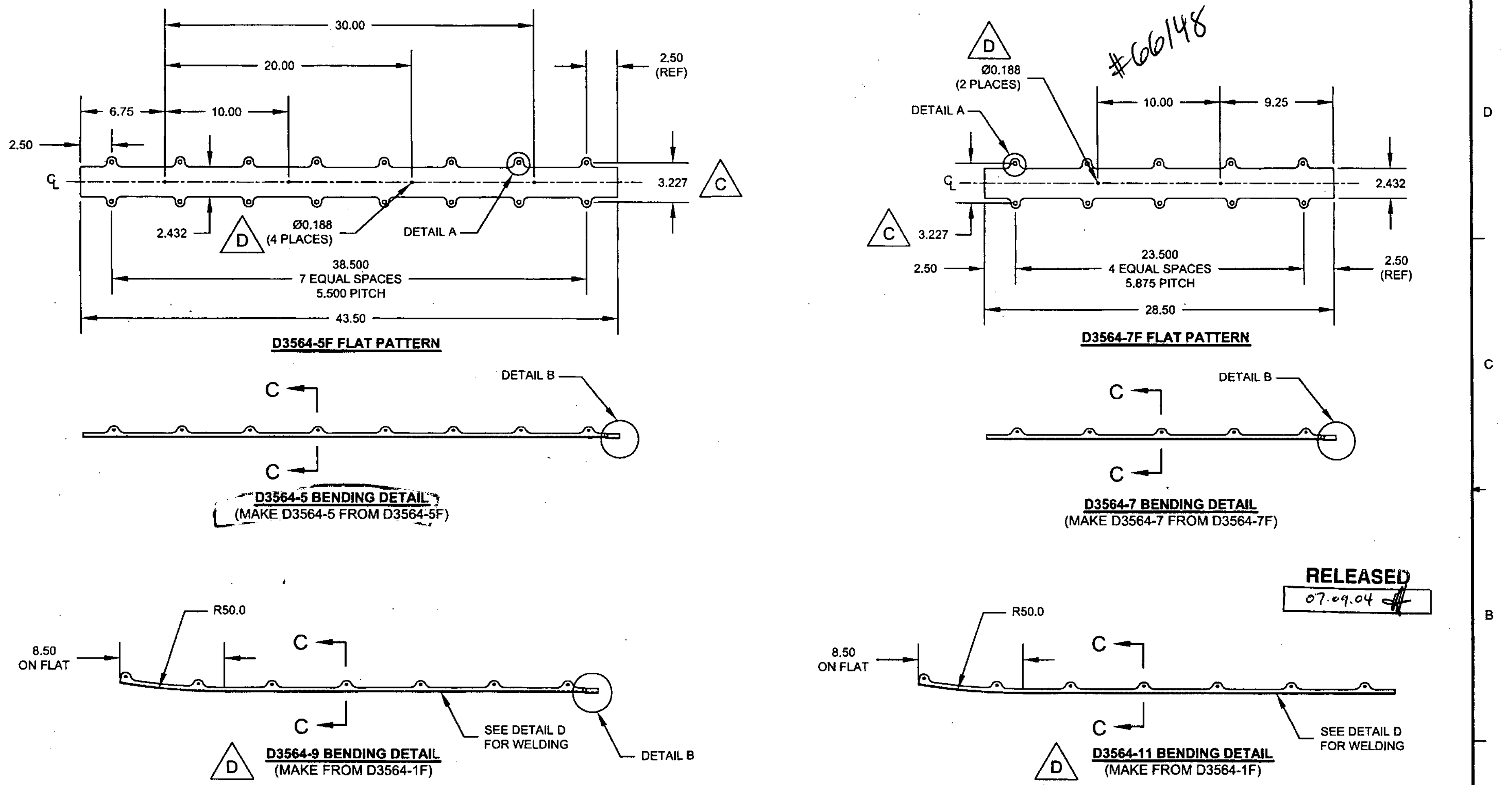
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	C.B	
CHECKED	PH	DRAWING NO. D3564 — REV. D — SHEET 2 OF 3
MFG. APPR.	[illegible]	
APPROVED	[illegible]	TITLE WEARSHOE — SCALE 1:8
DE APPR.	[illegible]	
DATE	07.08.21	

Dart Aerospace Ltd

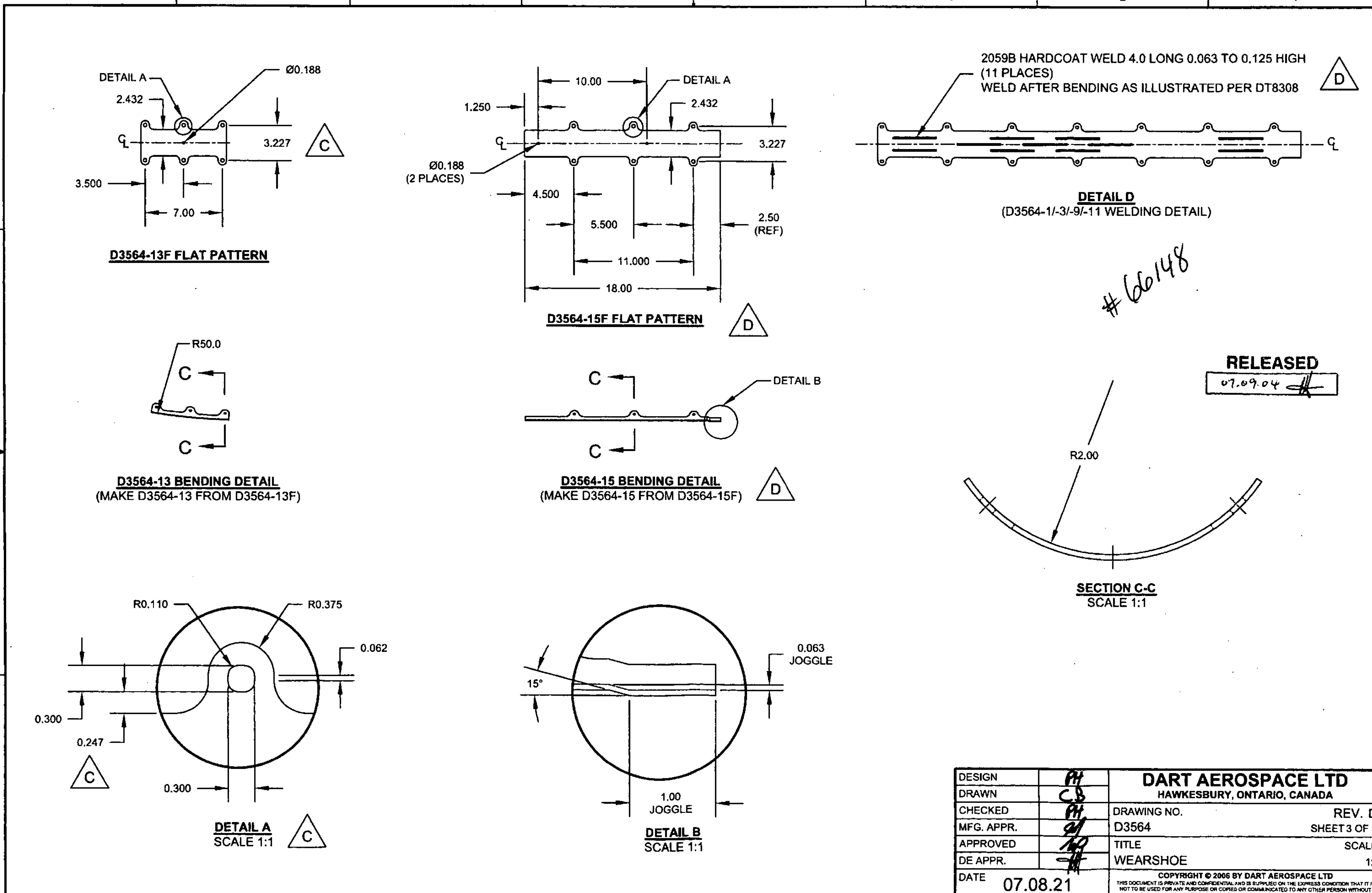
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DESIGN	PH		
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	[illegible]	D3564	SHEET 3 OF 3
APPROVED	[illegible]	TITLE	SCALE
DE APPR.	[illegible]	WEARSHOE	1:8
DATE	07.08.21		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	66148
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	✓		T 1801	
6.75	+/-0.030	6.75	✓		T	
10.00	+/-0.030	10.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
30.00	+/-0.030	30.00	✓		T	
2.50	+/-0.030	2.50	✓		V 1802	
3.227	+/-0.010	3.223	✓		V	
38.500	+/-0.010	38.500	✓		T	
5.500	+/-0.010	5.500	✓		T	
2.50	+/-0.030	2.50	✓		V	
2.432	+/-0.010	2.437	✓		V	
0.300 x 0.300	+/-0.010	.302 x .307	✓		V	
Ø0.188	+0.005/-0.001	.189	✓		V	
R0.375	+/-0.010	.375	✓		R.G	
0.063	+/-0.010	.059	✓		V	

Measured by:	IB	Audited by:	[signature]	Prototype Approval:	N/A
Date:	11-2-8	Date:	11.02.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD [signature]	[signature]

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries